

Work Order ID 135067

135067

Page 1

Tuesday, July 28, 2015 8:09:49 AM

Item ID: D205-626-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Handle™ LH
 Start Date: 7/28/2015 Start Qty: 2.00 ***P*3** Cust Item ID:
 Required Date: 7/31/2015 Req'd Qty: 2.00 ***P*** Customer:
 Reference:

Approvals: Process Plan: AME Date: 15-7-28 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D205-626	C								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP	D205-626-011		CHG 002					
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MLJ 1570-143

DAS
38
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15-10-15

3X
DAS
27
9-89
OCT 14 2015

DAS
02
9-89

DAS
38
9-89
15-10-15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Work Order ID 135067***135067***

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Tuesday, July 28, 2015 8:09:49 AM

Item ID: D205-626-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Handle™ LH

Stop ***NS2***

Start Date: 7/28/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/31/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D205-626-011
LOCATION : FG0173
OCT 15 2014DAS
6
9-89

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MCS OCT 15 2015

MCS OCT 15 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 1

Work Order ID: 135067

135067

Parent Item: D205-626-011

D205-626-011

Parent Item Name: Heli-Access-Handle™ LH

Start Date: 7/28/2015

Required Date: 7/31/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:B Reformat 00-03-03 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2480-011	DAS 38 9-89	Manufactured	No			110	Each	0.0000	1	3			
D2480-011										3			
Handle Weldment LH												DAS 27 9-89	DAS 02 9-89
AN526C632R7		Purchased	No			110	Each	134.0000	6	18			
AN526C632R7	DAS 38 9-89								**				
Screw												DAS 27 9-89	DAS 02 9-89
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				ST329	134					18			
				m129339	134					18			
NAS1149DN632J		Purchased	No			110	Each	269.0000	6	18			
NAS1149DN632J	DAS 38 9-89								**				
Washer												DAS 27 9-89	DAS 02 9-89
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				ST270	269								
				M127255	11								
				M128812	49								
				M132317	9					18			
				M132677	200					18			
MS21042L06		Purchased	No			110	Each	234.0000	6	18			
MS21042L06	DAS 38 9-89								**				
Nut													
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				ST304	101								
				m131294	1					18			
				m132803	100								
				ST305	133								
				m129499	3								
				m131317	130								

OCT 14 2015

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02
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

4. WEIGHT AND BALANCE

The following is the net weight increase associated with the D205-626 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-626-011	1.3 lb	-46.5 in	-60.5 in-lb	87.2 in	113.4 in-lb
Heli-Access-Handle Kit™, LH	0.59 kg	-1.18 m	-0.70 m-kg	2.21 m	1.31 m-kg
D205-626-012	1.3 lb	46.5 in	60.5 in-lb	87.2 in	113.4 in-lb
Heli-Access-Handle Kit™, RH	0.59 kg	1.18 m	0.70 m-kg	2.21 m	1.31 m-kg
D205-626-013	1.3 lb	-50.5 in	-65.7 in-lb	87.2 in	113.4 in-lb
Heli-Access-Handle Kit™, LH (Spacedoor™)	0.59 kg	-1.28 m	-0.76 m-kg	2.21 m	1.31 m-kg
D205-626-014	1.3 lb	50.5 in	65.7 in-lb	87.2 in	113.4 in-lb
Heli-Access-Handle Kit™, RH (Spacedoor™)	0.59 kg	1.28 m	0.76 m-kg	2.21 m	1.31 m-kg

5. PARTS LIST

Qty -011	Qty -012	Qty -013	Qty -014	Part Number	Description
X				D205-626-011	HELI-ACCESS-HANDLE™, LH (STANDARD)
	X			D205-626-012	HELI-ACCESS-HANDLE™, RH (STANDARD)
		X		D205-626-013	HELI-ACCESS-HANDLE™, LH (SPACEDOOR™)
			X	D205-626-014	HELI-ACCESS-HANDLE™, RH (SPACEDOOR™)
1		1		D2480-011	HANDLE ASSEMBLY, LH
	1		1	D2480-012	HANDLE ASSEMBLY, RH
		2	2	D2481	DOUBLER
		2	2	80-005-1-8	INSERT
6	6			AN526C632R7	SCREW
6	6			MS21042L06	NUT
		4	4	MS21042L08	NUT
		2	2	MS27039-0805	SCREW
		4	4	MS27039-0809	SCREW
6	6			NAS1149DN632J	WASHER (OR AN960JD6)
		10	10	NAS1149FN816P	WASHER (OR AN960-8L)